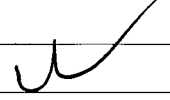


Work Order ID 50099

July 08, 2009 11:14:36 AM

Page 1

Item ID: D3145-1 Accept Setup Start
 Revision ID: B Stop
 Item Name: Bracket
 Start Date: 7/10/2009 Start Qty: 5.00 Cust Item ID:
 Required Date: 7/31/2009 Req'd Qty: 5.00 Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3145	Rev B								

100 BAND SAW 0.00
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

7-20-09/07/09

(5)

0

110 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Machine per Folio FA318 and Dwg D3145 Deburr and Tumble

DTT 09/07/10

(5)

3

(P10)

120 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

DTT 09/07/10

(5)

0




W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3145-1 PAR #: N/A Fault Category: Mach NCR ☒ Yes No DQA: AS Date: 09.07.21
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AS Date: 09.08.27

NCR: <u>50099</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/14	110	3 parts scrap. parts popped out of the vise during machining and at the same time the set bolt came loose from vibration. RC: process	<u>AS/KU2</u>	- Scrap & destroy Qty 3 - Replace x 3 m <u>17/24</u> - Ensure parts are snug as a bug	<u>AS</u> <u>09/07/14</u> <u>09.07.20</u>		<u>AS/KU2</u>	<u>09/07/14</u>

NOTE: Date & initial all entries

Work Order ID 50099

Page 2

July 08, 2009 11:14:36 AM

Item ID: D3145-1 Accept Setup Start
Revision ID: B Stop
Item Name: Bracket
Start Date: 7/10/2009 Start Qty: 5.00 Cust Item ID:
Required Date: 7/31/2009 Req'd Qty: 5.00 Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00	mk 09/07/15			5	0		
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00	JH 09-07-16			5			
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00	START TIME: 4:00AM OVEN TEMPERATURE: 9:30AM FINISH TIME: 320°F JH 09-07-16			5			

M112148

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50099

Page 3

July 08, 2009 11:14:36 AM

Item ID: D3145-1 Accept Setup Start
 Revision ID: B Stop
 Item Name: Bracket
 Start Date: 7/10/2009 Start Qty: 5.00 Cust Item ID:
 Required Date: 7/31/2009 Req'd Qty: 5.00 Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
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QC	<i>BK 09-07-16 (5)</i> Memo	0.00							
----	--------------------------------	------	--	--	--	--	--	--	--

Quality Control

170	Identify as per dwg & Stock Location: <i>67</i>	0.00							
-----	---	------	--	--	--	--	--	--	--

Packaging	Memo	0.00							
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Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

QC	Memo	0.00							
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Quality Control

9/1/20 (5) SK

09/07/20

u 9/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 08, 2009 11:14:36 AM

Work Order ID: 50099

Parent Item: D3145-1RevB

Parent Item Name: Bracket

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	30.0000	2.0174			

6061-T6 Bar 2.00 x 2.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	30	
110167	2.36	
13085	12	
17124	15.64	

17124 2.0174 *ml 09/07/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50099
Description: BRACKET		Part Number: D3145-1
Inspection Dwg:	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	±0.010	0.240	✓			
R0.250	±0.010	0.250	✓			2 PLCS
0.180	±0.010	0.180	✓			
1.250	±0.010	1.249	✓			
1.960	±0.010	1.964	✓			
Ø.221x0.351	±0.010 / ±0.010	0.220x0.341	✓			
28.9°	± 1/2°	28.9°	✓			
0.108	±0.010	0.108	✓			
R0.330	±0.010	0.330	✓			
0.125	±0.010	0.123	✓			
R0.188	±0.010	0.1875	✓			TYP
0.125	±0.010	0.115	✓			TYP
1.636	±0.010	1.630	✓			
95°	± 1/2°	95°	✓			
74°	± 1/2°	74°	✓			
R0.125	±0.010	0.125	✓			
0.219	±0.010	0.219				
9°	± 1/2°	9°	✓			
R0.387	±0.010	0.387	✓			
0.766	±0.010	0.766	✓			REF
0.250	±0.010	0.248	✓			
1.370	±0.010	1.365	✓			
0.760	±0.010	0.760	✓			

Measured by: DJA
Date: 09/07/10

Audited by: [Signature]
Date: 09/02/15

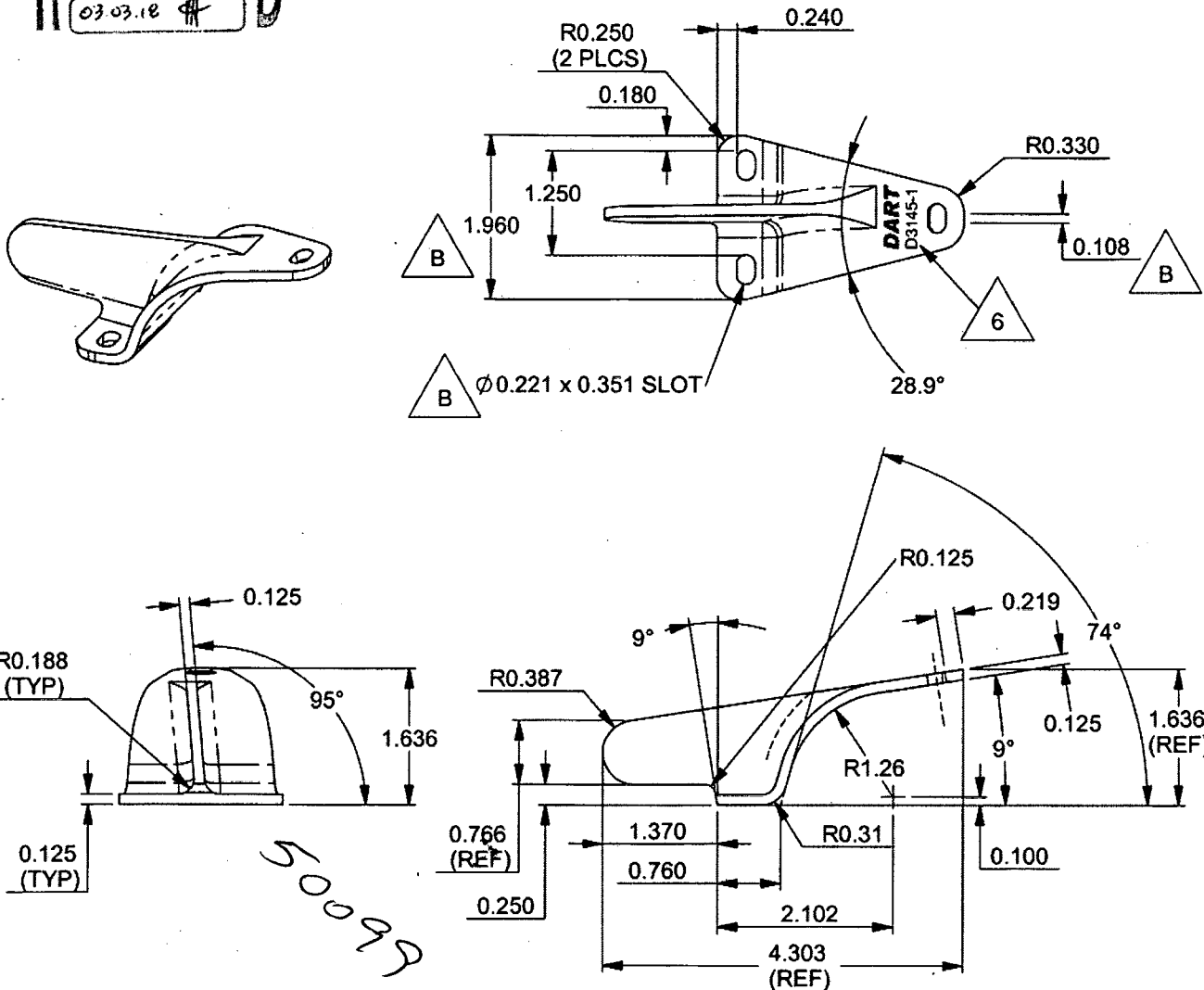
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03.03.18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries